

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010280**Date Inspected:** 27-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Gong Ling Zhu, An Qin Xiang.			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Tower Components		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 11, West tower, Lift 1 & 2.

- 1) Installing Interior Splice Plate On skin B.
- 2) AB/F carried out Magnetic Particle Testing (MT) Inside.

Bay 11, West tower, Lift 1 & 2.

- 1) Preparing for Installation of Interior Splice Plate On skin E.
- 2) AB/F carried out Magnetic Particle Testing (MT) Inside.

Bay10, South Tower, Interior Splice Plate Repair.

FCAW Repair welding of weld joint SSD1-SPSA3-56-3A(WRR # T-WR2527); located on Bay10, South Tower. Welders are identified as 062782; ZPMC Quality Control Inspector (QC) is identified as Gong Ling Zhu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-Repair.

Bay11, West Tower, Lift 4, BC & AB Corner Seam Ring Area.

SMAW welding of weld joint WSTL4-2B/L-58A, 59A; located on Bay11, West Tower, Lift 4, BC & AB Corner Seam Ring Area. Welders are identified as 040611, 202323; ZPMC Quality Control Inspector (QC) is

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identified as An Qin Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: 1) WPS-B-P-214-C-U2, 2) WPS-B-P-214-B-U2.

Bay 11, West Tower, Lift 2.

During Random in Process inspection this QA Inspector observed ZPMC cutting out B/C corner Diagonal Stiffener. The attached photographs provide additional detail.

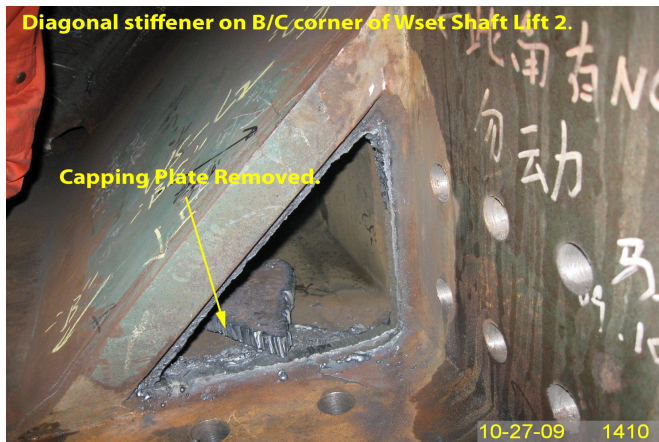
This QA Inspector carried out NDE on following

Bay 10, East Tower, Web Plate of Struts.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

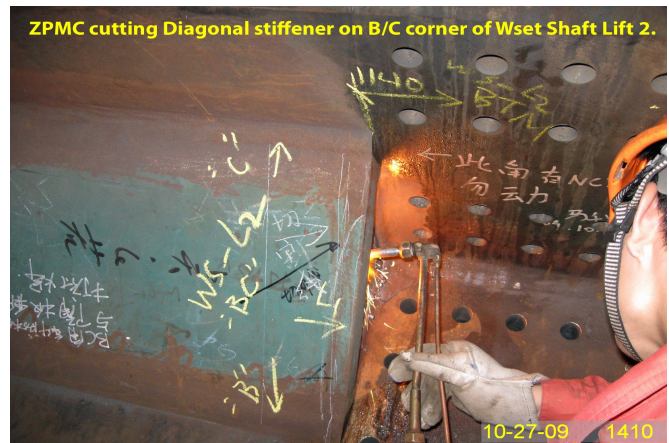
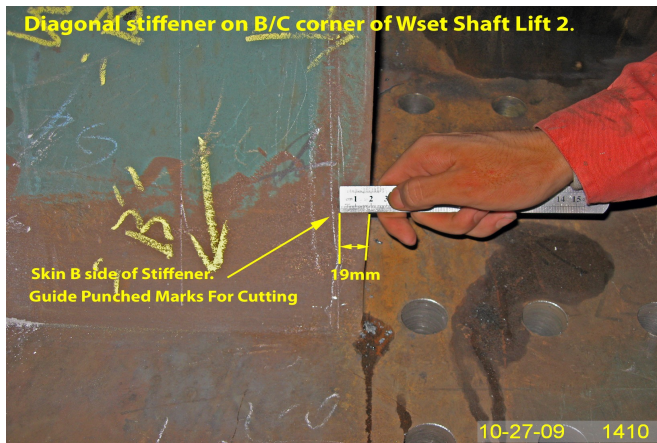
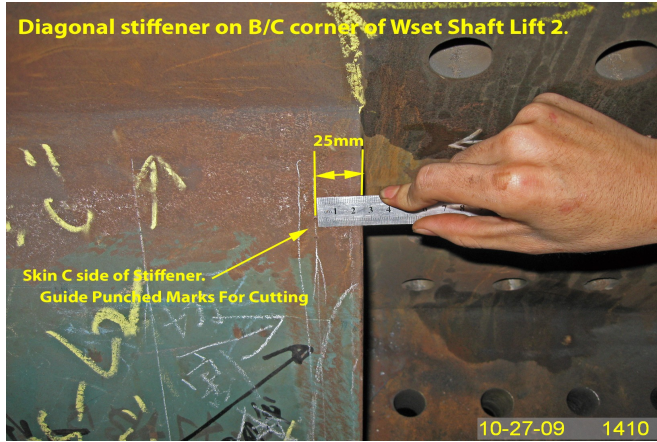
- 1) ED1-STSA3-2-89M-1-1, 2, 4, 6.
- 2) ED1-STSA3-2-89M-2-1, 2, 4, 6.
- 3) ED1-STSA3-2-99M-1-1, 2, 4, 6.
- 4) ED1-STSA3-2-99M-2-1, 2, 4, 6.
- 5) ED1-STSA3-2-109M-1-1, 2, 4, 6.
- 6) ED1-STSA3-2-109M-2-1, 2, 4, 6.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

**Inspected By:** Juvekar,Amit  
**Reviewed By:** Clifford,William

**Quality Assurance Inspector**  
**QA Reviewer**